

Work Order ID 110882

110882

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Item ID: D3777-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 1/08/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 12.00 ***12*** ***14*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-01-09 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3777	Rev A

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3777-1 Dwg Rev: A Prog Rev: A 2-
 Debur if necessary
304-032

15 0 De
 03-04-14

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

14 0 De
 03-04-14

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

DAS
 27
 9.89
 14/8/14

14 0 De

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Item ID: D3777-041 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Clamp
Start Date: 1/08/14 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 1/08/14 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 14/3/17				14			

170 *170* Packaging Packaging	Identify as per dwg & Stock Location: (12x) 5T 457 Memo ship 2x	0.00				14x	DAS 28 9-89	14-03-18	
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180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00						14-03-18	
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14-03-18

Picklist Print

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Work Order ID: 110882
 Parent Item: D3777-041
 Parent Item Name: Clamp

Start Date: 1/08/14 Required Date: 1/08/14
 Start Qty: 12.00 Required Qty: 12.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
 IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2182B013 Rubber Cushion		Manufactured	No			100	Each	0.0000	1	12			
M304S22GA 304/316 .032 Sheet		Purchased	No			150	sf	282.9800	0.02	0.2526312			

Location

MAT020

m126593

Loc Qty

282.98

282.98

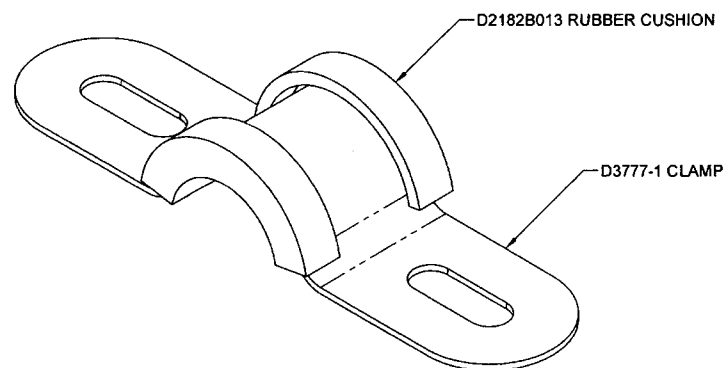
Loc Code

126593 → 1253

14-03-17

03-04-14

QTY	P/N	DESCRIPTION
-041		
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



D3777-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

110882 M5
1401-09

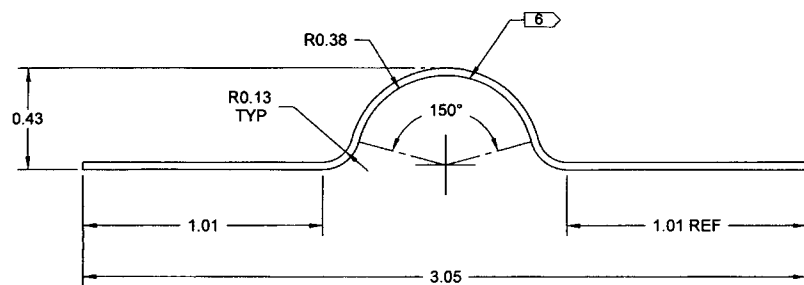
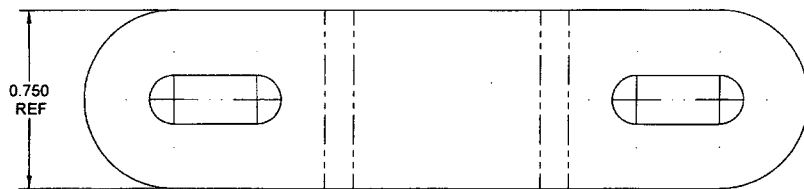
RELEASED
08.10.25

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.25		

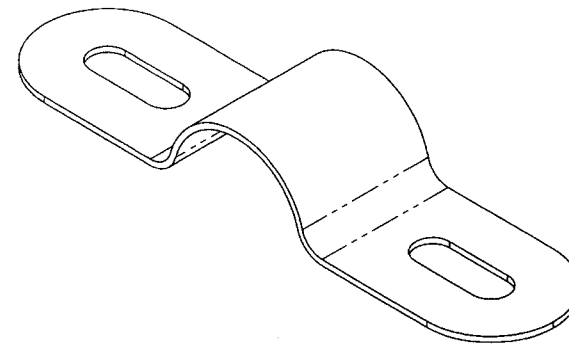
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3777** REV. A
SHEET 1 OF 3
TITLE **CLAMP** SCALE NTS

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D3777-1 CLAMP



NOTES:

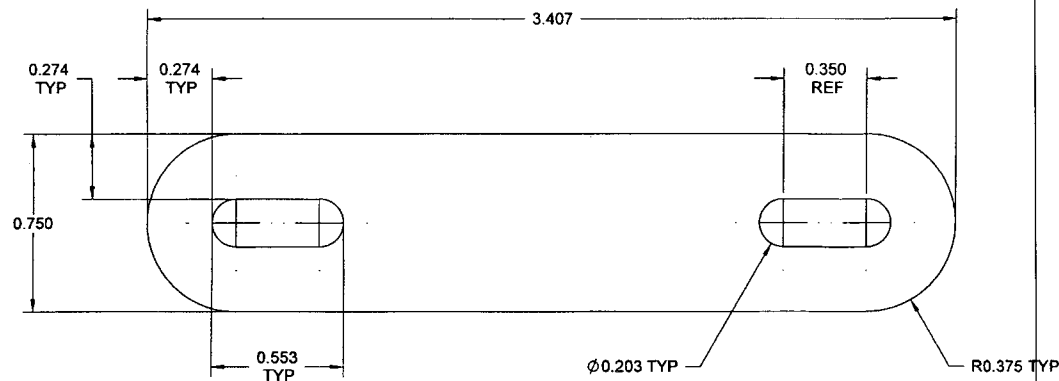
- 1) MATERIAL: MAKE FROM D3777-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 0.02 lbs

RELEASE
08-10-15

DESIGN	00	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	00		
CHECKED	00	DRAWING NO.	REV. A
MFG. APPR.	00	D3777	SHEET 2 OF 3
APPROVED	00	TITLE	SCALE
DE APPR.	00	CLAMP	NTS
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8 7 6 5 4 3 2 1

D



D3777-1F CLAMP

B

A

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

RELEASED
08.10.15

DESIGN	00	DART AEROSPACE LTD	
DRAWN	00	HAWKESBURY, ONTARIO, CANADA	
CHECKED	00	DRAWING NO. D3777	REV. A
MFG. APPR.	00	SHEET 3 OF 3	
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